

SHIP JUNE 3

Work Order ID 119135

119135

Page 1

Item ID: D412-726-141

Accept:

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate LH Standard Skidtube - OEM Replacement

Start Date: 5/12/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D412-726

B

100

Document Control

0.00

DAS
27
9-89

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D412-726-142 CHG002

JUN 03 2014

MCS 140527

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

20X

DAS
28
9-89

MAY 27 2014

120

QC4- 100% Inspect kits for completeness

0.00

DAS
27
9-89

120

QC

Memo

0.00

Quality Control

JUN 03 2014

20

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, May 09, 2014 12:40:00 PM

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Work Order ID: 119135

119135

Parent Item: D412-726-141

D412-726-141

Parent Item Name: Wearplate LH Standard Skidtube - OEM Replacement

Start Date: 5/12/14

Required Date: 5/30/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A05.05.12New issueKJ/JLM
PER ECN13-519 DD VERF:JLM

IPP REV:B 13.02.19 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3-5A		Purchased	No			110	Each	979.0000	40	800			
AN3-5A													
Bolt													

Location	Loc Qty	Loc Code
GA	45	
117423	45	
ST511	832	
m126559	832	
ST512	102	
124561	102	

DAS 28 MAY 27 2014

9-89

D3315-1		Manufactured	No			110	Each	4.0000		20			
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D3315-1

Wearplate LH Fwd

DAS
06
9-89

Location	Loc Qty	Loc Code
ST500	4	
98396	4	

DAS 28 16x / 1/9/38
9-89

D3315-3		Manufactured	No			110	Each	6.0000		20			
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D3315-3

Wearplate LH Center

DAS
06
9-89

Location	Loc Qty	Loc Code
ST500	6	
94932	6	

DAS 28
9-89

14x 15/1/39

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 119135

119135

Parent Item: D412-726-141

D412-726-141

Parent Item Name: Wearplate LH Standard Skidtube - OEM Replacement

Start Date: 5/12/14

Required Date: 5/30/14

Start Qty: 20.00

Required Qty: 20.00

D3315-5

Manufactured No

110

Each

12.0000

20

D3315-5
Wearplate LH Aft

DAS
06
9-89

Location

Loc Qty

Loc Code

ST500

12

94937

4

95154

2

95912

6

NAS1149D0332J

Purchased

No

110

Each

5,499.000

40

800

NAS1149D0332.J

Washer

Location

Loc Qty

Loc Code

ST294

513

m128606

513

ST510a

4986

m128612

4986

DAS

28

9-89

MAY 27 2014

DAS

28

9-89

119213 X12

800

DQA: _____ Date: _____



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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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4.0 WEIGHT AND BALANCE

There is negligible weight change associated with the installation of the Dart wearplates.

5.0 PARTS LIST

Qty -111	Qty -141	Qty -142	Qty -211	Qty -241	Part Number	Description
X					D412-726-111	WEARPLATE KIT (205/212/412 Standard Skidtubes)
	X				D412-726-141	WEARPLATE KIT (205/212/412 Standard Skidtubes), LH
		X			D412-726-142	WEARPLATE KIT (205/212/412 Standard Skidtubes), RH
			X		D412-726-211	WEARPLATE KIT (412 Float Skidtubes)
				X	D412-726-241	WEARPLATE KIT (412 Float Skidtubes), LH/RH
1					D3315-1	WEARPLATE (LH FWD)
1					D3315-2	WEARPLATE (RH FWD)
1					D3315-3	WEARPLATE (LH CENTER)
1					D3315-4	WEARPLATE (RH CENTER)
1					D3315-5	WEARPLATE (LH AFT)
1					D3315-6	WEARPLATE (RH AFT)
			2	1	D3321-1	WEARPLATE (LH FWD, RH MIDDLE)
			2	1	D3321-2	WEARPLATE (RH FWD, LH MIDDLE)
			2	1	D3321-3	WEARPLATE (AFT END)
80			80	40	AN35A	BOLT
80			80	40	AN960JD,10Z	WASHER

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Date: 06.03.08